

Date: Thursday, 12/20/2007 3:21:47 PM
User: Kim Johnston

Process Sheet

SPLIT - 1

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GROMET
Job Number	: 36488 <i>u1</i>		
Estimate Number	: 12820		
P.O. Number	: N/A	Part Number	: D36192
This Issue	: 12/20/2007 S.O. No. : N/A	Drawing Number	: D3619 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: A
Previous Run	: 34611	Material	: N/A
Written By	:	Due Date	: 1/4/2008
Checked & Approved By	: <i>HJ 07/12/21</i>	Qty:	20
Comment	: Est Rev.A New Issue 07-04-09 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	9610K18	GROMMET
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) GROMMET	
2.0	PG	PURCHASING
	Comment: Issue P/O: <i>5338</i>	<i>C 207112121</i>
	Purchase Part Number: 9610K18	
	Supplier: MC MASTER CARR	
	Certificate of conformity is required	(20)
3.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1	
	Receive & Inspect For Transit Damage	<i>7/12/27 SQ</i>
	Ensure material certification is attached	<i>7/12/27 SQ</i>
4.0	QC6	DIMENSIONAL CHECK
	Comment: DIMENSIONAL CHECK	<i>C 207112102 X15</i>
5.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1	
	****Remove supplier paperwork from box.*****	
	Identify and Stock	
	Location: <i>S112 over stcked</i>	<i>AS 01/02/08 X15</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/01/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: GROMET

Job Number: 36488

Part Number: D36192

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(15)

Comment: FINAL INSPECTION/W/O RELEASE

12/20/07

Job Completion



un 2007.13 c2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

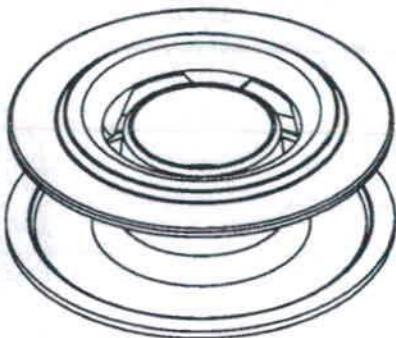
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3619	REV. A	SHEET 1 OF 1
DATE 07.03.26		TITLE GROMMET	SCALE NTS	
REV A	DATE 07.03.26	DESCRIPTION NEW ISSUE		

SPECIFICATION CONTROL DRAWING



RELEASED
07 04 02 *[Signature]*

D3619-X GROMMET,
WHERE X REPRESENTS THE GROMMET TRADE SIZE

DART P/N	TRADE SIZE	DESCRIPTION	HOLE SIZE	MAX. MTL THICKNESS	MCMASTER CARR P/N
D3619-0	0	BRASS GROMMET W/ TEETH	1/4	0.110	9610K16
D3619-1	1	BRASS GROMMET W/ TEETH	9/32	0.120	9610K17
D3619-2	2	BRASS GROMMET W/ TEETH	3/8	0.150	9610K18
D3619-3	3	BRASS GROMMET W/ TEETH	7/16	0.230	9610K19
D3619-4	4	BRASS GROMMET W/ TEETH	1/2	0.300	9610K21

NOTES:

- 1) PURCHASE INFO: MCMASTER-CARR P/N'S INCLUDE THE FOLLOWING:
48 GROMMETS FOR SIZE 0 & 1,
24 GROMMETS FOR SIZE 2, 3 & 4,
D3619-XT1 HOLE PUNCH,
D3619-XT2 STRIKER BLOCK,
D3619-XT3 PUNCH AND
D3619-XT4 DIE

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *36488*



McMASTER-CARR

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Aurora, OH 44202-8087
330-995-5500
cle_sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen
Hawkesbury, ON K6A 1K7
Canada

Purchase Order
5338

Page 1 of 1

McMaster-Carr Number
4491063-02

12/21/2007

Line	Description	Ordered	Shipped	
1	9510K18 Military Specification Brass Grommet Kit, with 10 Teeth, Trade Size 2, 2 Grommets, 3/8" Hole Size	20 Each	15	2 - 41 -01 06-79 K18 15 EA

Shipped separately from our Chicago warehouse on 12/2

1 9510K18 Military Specification Brass Grommet Kit, with 10 Teeth, Trade Size 2, 2 Grommets, 3/8" Hole Size 20 Each 5

Dart Aerospace Ltd

FYR

